



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1815

Job Sheet 168295



Part No: 647.1815

Job Qty: 4 ea

Part Name: Gusset RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 5 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/27/17	0.00	0.00	Start Up Container		SC 17/12/23
110	Waterjet	4 pcs		11/27/17	0.00	0.52	Waterjet1		SC 17/12/23
120	QC	4 pcs		11/27/17	0.00	0.00	QC2		SC 17/12/23
130	QC	4 pcs		11/27/17	0.00	0.00	QC8		
140	Brake NC	4 pcs		11/27/17	0.00	0.41	Brake NC 1		DAS 38 SD
150	QC	4 pcs		11/27/17	0.00	0.00	QC5		38
160	Outsource	4 pcs		11/27/17	0.00	0.00	Outsource4		9-89 C-18-6-28
170	Packaging	4 pcs		11/27/17	0.00	0.00	Packaging2		9-89 18.07.05
180	QC	4 pcs		11/27/17	0.00	0.00	QC5		38
190	SprayPaint	4 pcs		11/28/17	0.00	0.42	Spray Paint		9-89
200	QC	4 pcs		11/28/17	0.00	0.00	QC14		
210	Packaging	4 pcs		11/28/17	0.00	0.00	Packaging3		9-89 JUL 24 2018
220	QC21-SA	4 Ea		11/28/17	0.00	0.00	QC21		9-89 JUL 24 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 160 - ISSUE P/O: 040356 HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH: _____

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	0	236	0	0
	138389	04			

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:46 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Skid-tube ☐ Machining ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com </td> <td style="width:33%; vertical-align: top;"> Cross tube ☐ Lab ☐ Eng ☐ Test ☐ </td> <td style="width:33%; vertical-align: top;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> </tr> <tr> <td colspan="2"></td> <td style="vertical-align: top;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>		Skid-tube ☐ Machining ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Cross tube ☐ Lab ☐ Eng ☐ Test ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐			Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Cross tube ☐ Lab ☐ Eng ☐ Test ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐							
		Engineering ☐ Quality ☐ Other ☐							
DART AEROSPACE S026918 Gusset RH PART NO: Revision: Operation: Change No: 647.1815 Start up Operation Mfg Date: 12/23/17 Job No: 168295									

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03686				SHEET 1 OF 2	
	DWG NO. 647.1800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	EFFECT ON DWG ☒ INC. ☐ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED RADIUS ON SHEETMETAL BEND.				ECR: D-12-020	

NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 1 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

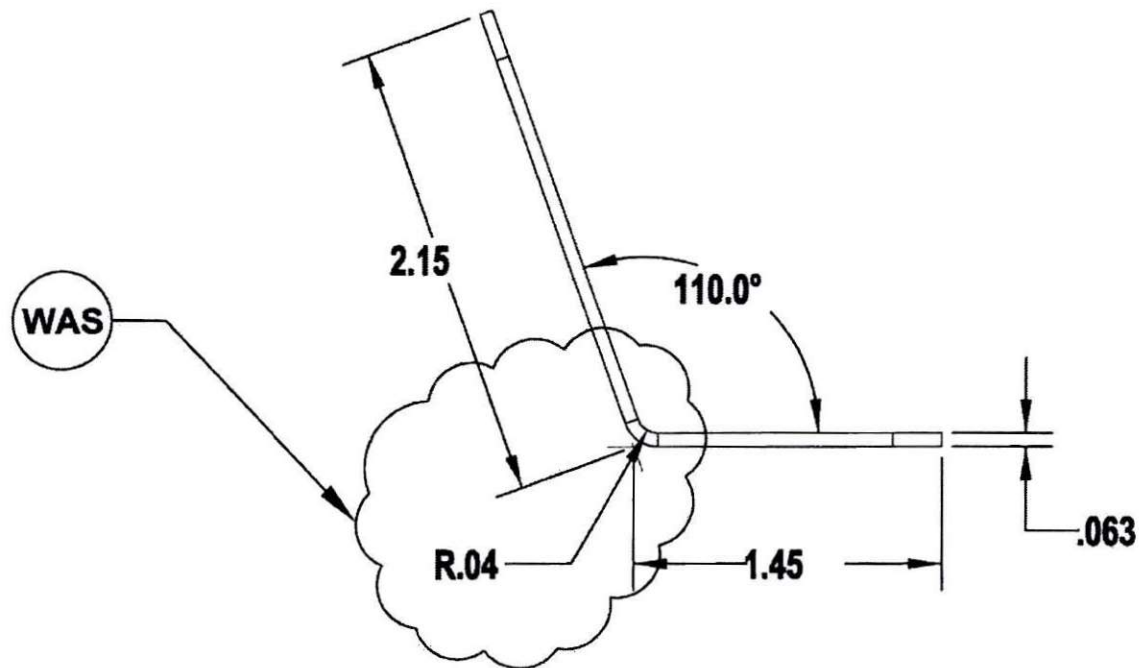
SHEET 1, ZONE A1 WAS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168295

DAS
30
9-89

NOV 16 2017

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



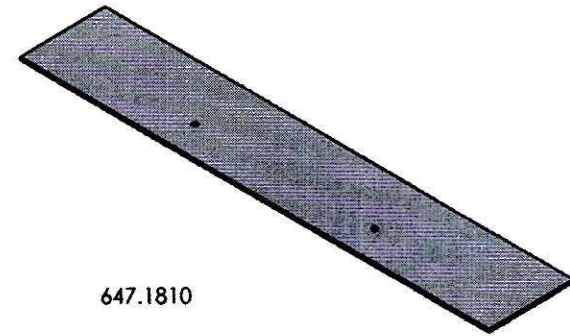
SHEET 4, ZONE D5 WAS:

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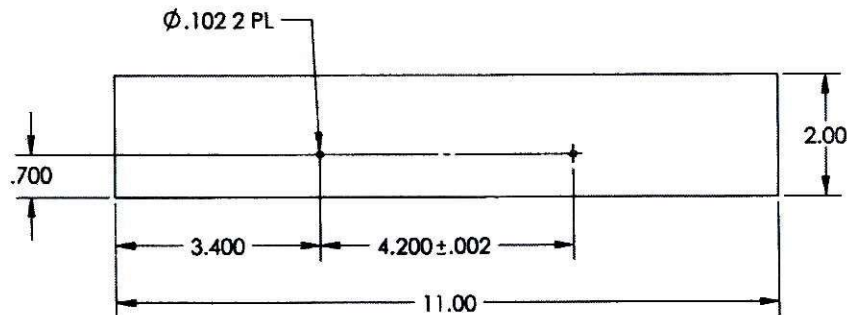
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION 792		N/C
N/C	INITIAL RELEASE	06/01/08	P. BRAVO
A	INCORPORATED ECH 03488	11/12/12	P. BRAVO

NOTES:

1. PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.1810



.063

	647.1818	NOSE DOOR SPACER	△	△
	647.1817	SUPPORT, RH	△	△
	647.1816	SUPPORT, LH	△	△
	647.1815	GUSSET, RH	△	△
	647.1814	GUSSET, LH	△	△
	647.1813	ANGLE	△	△
	647.1812	SHIM	△	△
	647.1811	SPACER	△	△
	647.1810	NOSE DOOR DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL SPEC.

QTY	PARTS LIST	
NEXT ASSY (S)	APICAL INDUSTRIES	
647.1300	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	SHEETMETAL	
ORIGINAL DATE 08-01-00 DIM-CAL-TN 08-01-00 DRAWN BY J.G.ARONER P. BRAVO DRAWING APPROVAL 08-01-00 CONFIRMATION	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°	REV 8 DATE 07/02/06 SCALE NONE
	DWD NO 647.1800 SHEET 1 OF 7	REV A

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.25 X 45.0°
4 PL

1.00

3.63

.063

647.1811

ORIGINAL DATE
06/04/09
DRAWN BY
J. GARDNER
CHECKED
P. BRAVO
DRAWING APPROVAL
P. BRAVO
DATE
CONTRACT NO.

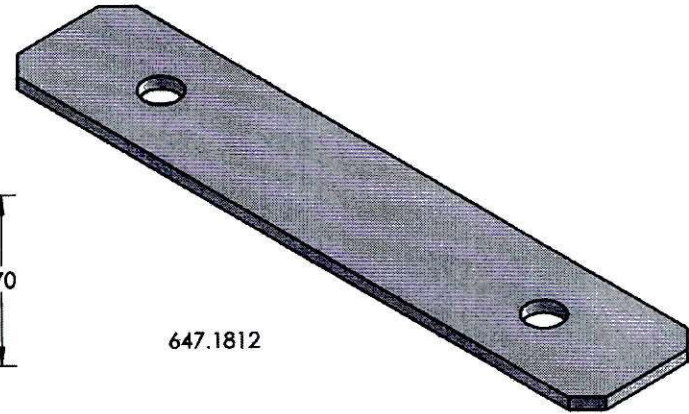
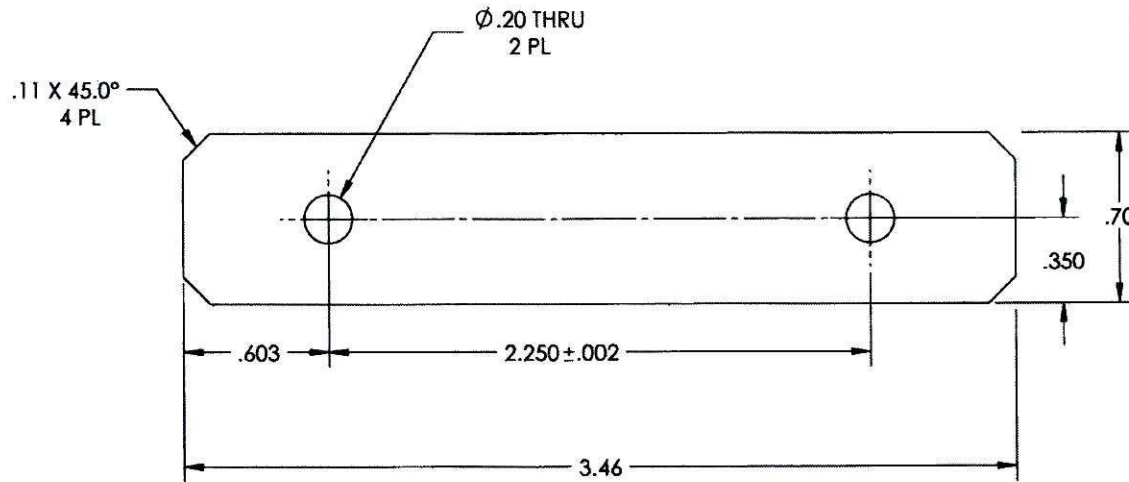
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA 92056-3512 (760)724-5300

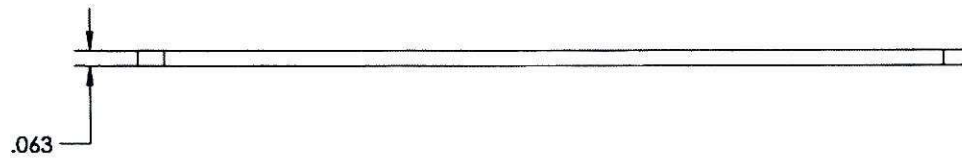
SHEETMETAL

REV	CAGE CODE	DWG. NO.	REV.
B	07M26	647.1800	A
SCALE: NONE			SHEET 2 OF 7

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647.1812



ORIGINAL DATE REV. DATE DRAWN BY J. GAUBER DRAWING APPROVAL P. BRAVO CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SHEETMETAL	
SIZE B	CAGE CODE 07M26	DWG. NO. 647.1800	REV. A
SCALE: NONE		SHEET 3 OF 7	

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.23 X 45.0°
PL

UP 70.0° R .13

(1.42) (2.11)
3.53

FLAT PATTERN

3.63

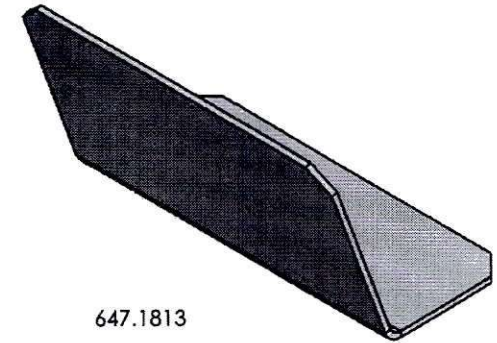
2.15

110.0°

R.125

1.45

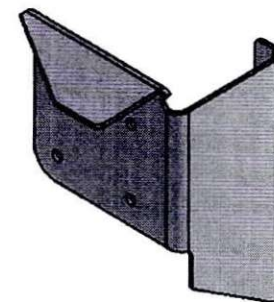
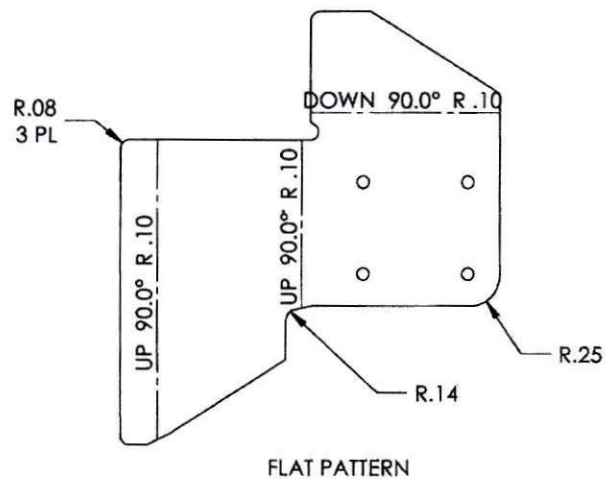
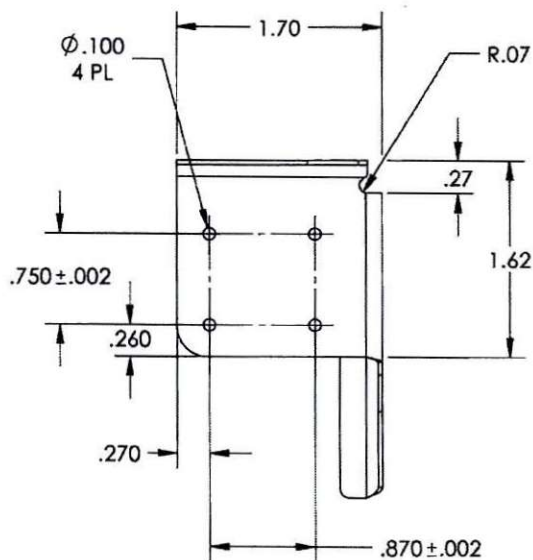
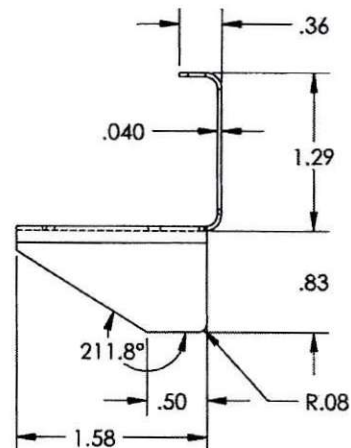
.063



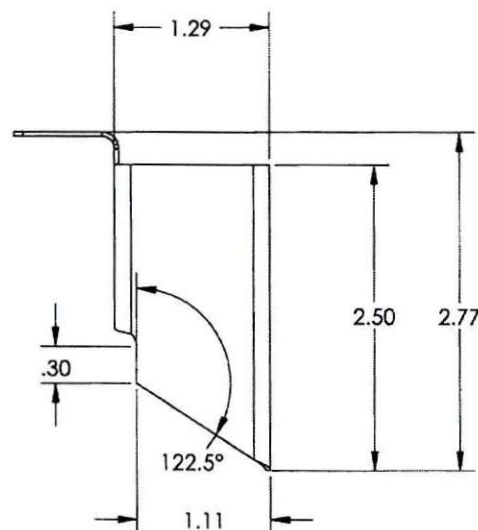
647.1813

ORIGINAL DATE 10/20/01		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CONTRACT NO.		647.1800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV A
		CAGE CODE 07M126	SCALE: NONE
		DWG. NO. 647.1800	SHEET 4 OF 7

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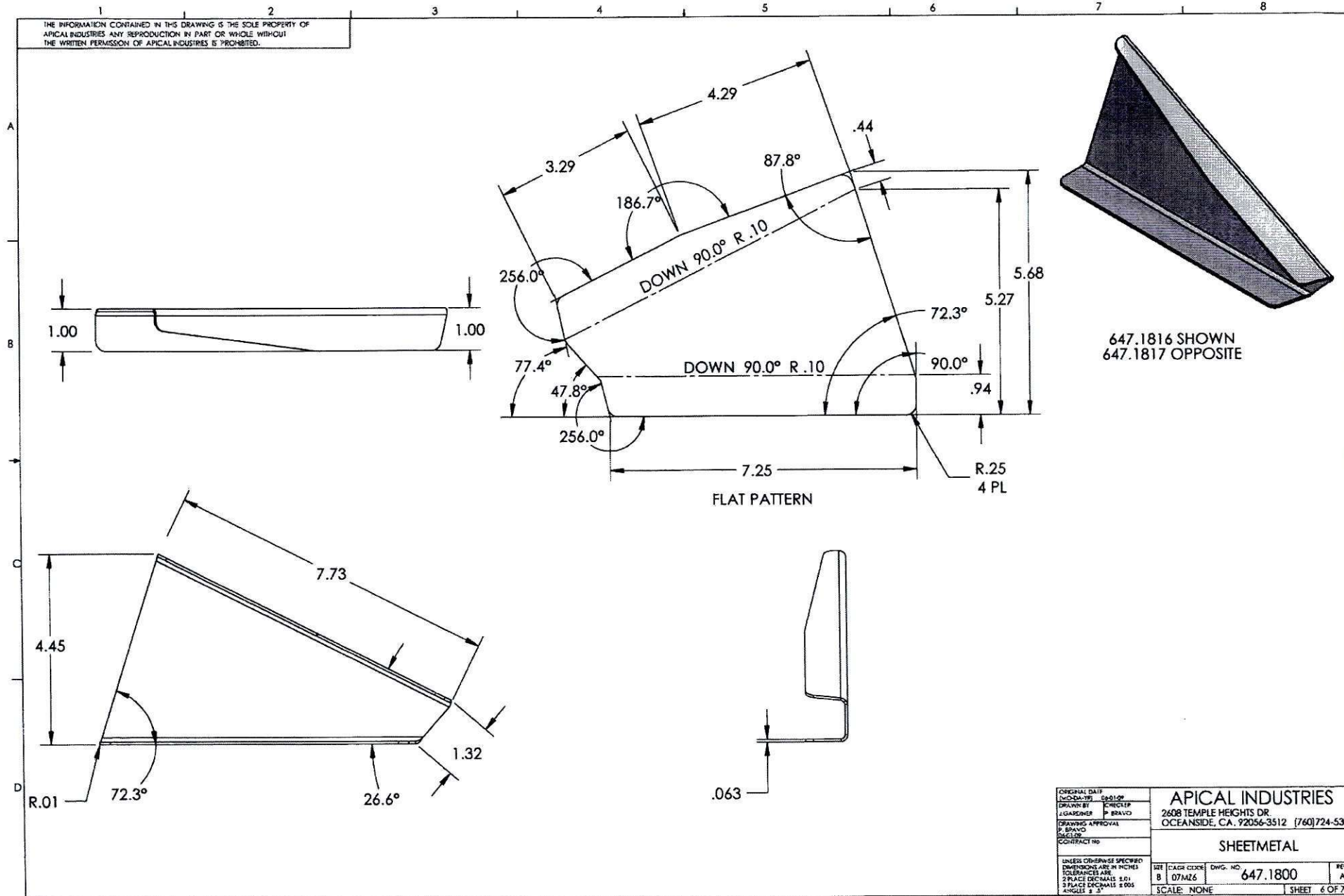


647.1814 SHOWN
647.1815 OPPOSITE



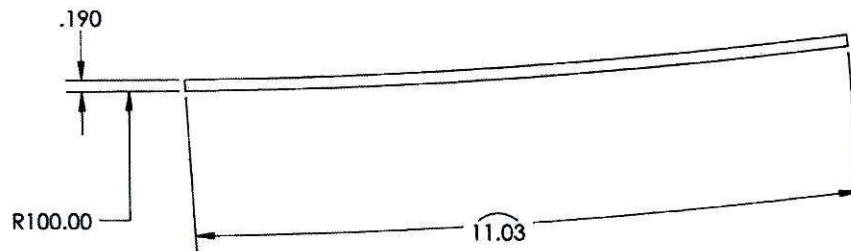
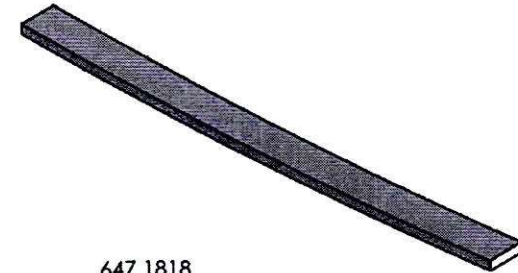
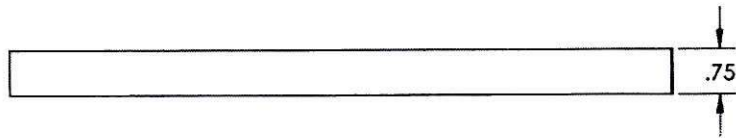
ORIGINAL DATE: 06-21-04		APICAL INDUSTRIES	
DRAWN BY: CHICKER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. BRAND		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: P. SPAYO		SHEETMETAL	
SHEET: 5 OF 7		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV: A	

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ORIGINAL DATE		APICAL INDUSTRIES	
DESIGNED BY	SP-1007	2608 TEMPLE HEIGHTS DR.	
DRAWN BY	CHICKLEP	OCEANSIDE, CA. 92056-3512 (760)724-5300	
ENGINEER	P. BRAVO	SHEETMETAL	
DRAWING APPROVAL		UNLESS OTHERWISE SPECIFIED	
BY		DIMENSIONS ARE IN INCHES	
DATE		TOLERANCES ARE:	
CONTRACT NO.		2 PLACE DECIMALS ±.01	
		3 PLACE DECIMALS ±.005	
		ANGLES ± 3°	
SHEET 6 OF 7		DWG. NO. 647.1800	
SCALE: NONE		REV. A	

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ORIGINAL DATE 10-01-1981		DESIGNER J. GARDNER		CHECKED P. BRAVO	
DRAWN BY J. GARDNER		DRAWING APPROVAL P. BRAVO		CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°					
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		SHEETMETAL			
SIZE B	CAGE CODE 07M26	DWG. NO. 647.1800	REV A		
SCALE: NONE		SHEET 7 OF 7			

INSPECTION SHEET

DATE
30

271



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040356

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040356
PO Date: 6/28/18
Due Date: 7/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178641	SWA10A-700	Wire Clamp -Issue P/O to ATG: _____ -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	7/13/18	40 pcs	0 pcs	40 pcs	\$8.00/pcs	\$320.00
2	179370	647.7811	Bracket B Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$16.75/pcs	\$67.00
3	179369	647.7810	Bracket A Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	6 pcs	0 pcs	6 pcs	\$16.75/pcs	\$100.50
4	168294	647.1814	Gusset LH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60
	168028			Firmed	7/13/18	10 pcs	0 pcs	10 pcs	\$9.15/pcs	\$91.50
Sub Total:						14	0	14		\$128.10
5	173890	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	7/13/18	12 pcs	0 pcs	12 pcs	\$12.25/pcs	\$147.00
6	168295	647.1815	Gusset RH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60

DAS
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
40 ea	Part: SWA10A-700 Wire Clamp Hard Anodize per MIL-A-8625F, Type III, Class 2, Black, .0005-.0045" (.5 - 4.5mils) Job: 23372		Rev: 4 PO: PO040356 Line: 1
4 ea	Part: 647.7811 BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23373		Rev: A PO: PO040356 Line: 2
6 ea	Part: 647.7810 Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23374		Rev: A PO: PO040356 Line: 3
14 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23375		Rev: A PO: PO040356 Line: 4 7
4 ea	Part: 647.1815 Gusset RH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23380		Rev: A PO: PO040356 Line: 6
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>4/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			